

Date: Monday, 10/22/2007 10:34:31 AM
User: Jim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP WELDMENT
Job Number	35262	Part Number	D3562041
Estimate Number	12576	Drawing Number	D3562 UNDER REVIEW OK PER REV. C
P.O. Number	N/A	Project Number	N/A 07-10-22 DC
This Issue	10/22/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	LARGE FAB ASSY
First Issue	N/A	Drawing Revision	C
Previous Run	34269	Material	N/A
Written By		Due Date	11/10/2007 Qty: 5 Um: Each
Checked & Approved By	HJ 07.10.22		
Comment	Est Rev A	New Issue	06-11-09 JLM
	Est rev B	ECN 987	07.10.09 EC verified by: DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Qty	Part #	Description
1	D2622-120C	Extrusion
Batch: 334016		
Check Material for any Dents or Defects		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2622 extrusion as per Dwg D3562		
2-Deburr and bevel ends for welding		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07.11.22 5

6.0 D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT R35039

a.m 07.11.22 5

7.0 D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: R35031

a.m 07.11.22 5

8.0 MS20600AD4W5

Blind Rivet



yws



(P70)

Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)

Blind Rivet

batch: M106074 12Y M105953 yws

a.m 07.11.22

5

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch: M105379

a.m 07.11.22 5

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07.11.22 (4)

11.0 D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

H 01-11-22 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-11-22	8.0	MS					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-22	8.0	MS 20600AD4W5, there are no more in stock.	J 071122	It is acceptable to MS 20600AD4W4 Qty 12 12 B m105953	Q.M 07-12-06	J 07-12-06	J 071122	J 0711-22

NOTE: Date & initial all entries

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Job Number: 35262		Part Number: D3562041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
2	D2734	End Cap 334485
12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod M105058		16 07.11.22 4
2-Grind end cap welds flush as per Dwg D3562		6. m 07.11.23 4
13.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		1D 07.11.23 (4)
14.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		6 07.11.26 (4)
15.0	POWDER COATING	POWDER COATING 07-11-26 (X4) TOUCH-UP Alodine M105914
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		m. / 07.11.26 (4X)
16.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3562 and QSI 005 4.4 Batch: m 105030		Bl 07.11.27 (4)
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		C 07.11.27
18.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Assembly Kit		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes O No D DQA: D Date: 01/21/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/22/07 (4)

Job Completion



4 Oct. 11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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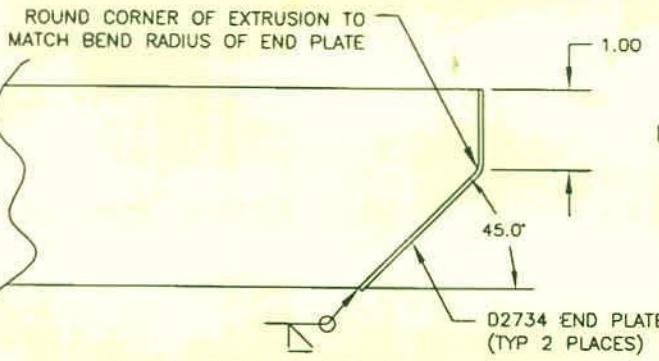
NOTE: Date & initial all entries

DART

RELEASED

UNDER REVIEW

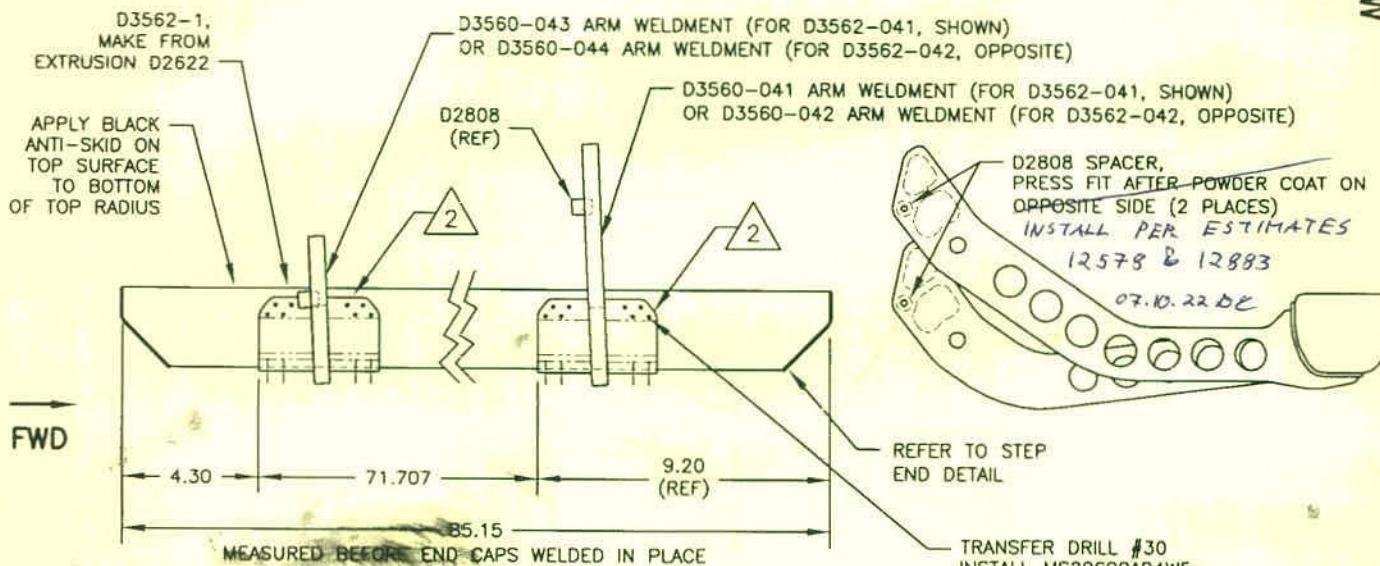
DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.		REV. C
		D 3562		SHEET 1 OF 1
DATE		TITLE	STEP ASSEMBLY	SCALE
07.06.19		A	06.09.26 NEW ISSUE	NTS
		B	07.01.15 ARMS NOW RIVETED TO STEP	
		C	07.06.19 NOW MAGBND, ADD D2808, RMV 4 RVTS	



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

~~07.10.22 DC~~
OK PER REV. C
07.10.22 DC

TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)

D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

